

Work Order ID 101834-2

May-13-13 1:15:15 PM

101834

Page 1

Item ID: D2230-1

Accept

Revision ID:

Item Name: Lug

Start Date: 5/13/13 Start Qty: 320.00

SPK/T
200

320

Required Date: 5/31/13 Req'd Qty: 320.00

320

Reference:

Approvals: Process Plan: CL

Date: 13/05/14

Tooling:

Cust Item ID:

Customer:

QC:

Date:

SPC (Y/N):

Date:

Date:

Setup

Start

NS1

Stop

NS2

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100	BAND SAW								
Bandsaw									
Jeaspa Bandsaw									
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Search								
HAAS CNC vertical machine #1									

Memo
Cut D2423 extrusion to 0.82"
Batch:

cut @ metec

Memo
1-Machine per folio FA927
DWG REV:
FOLIO REV:
(Check for crack while loading into the machine.)
2- deburr rough edges

issee P/O to metec

Machine is per drawing D2230 Rev. A

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Page 2

Item ID: D2230-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lug

Stop

NS2

Start Date: 5/13/13

Start Qty: 320.00

320

Cust Item ID:

Required Date: 5/31/13

Req'd Qty: 320.00

320

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

120 *need*

120

QC

Quality Control

Operation
Description

QC2-Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

1/3/15 200

Memo

0.00

need + inspect

attached c of c to w/c

130

130

QC

Quality Control

QC3-Inspect parts - second check

0.00

BS 21

200

Memo

0.00

BS 15

140

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

200 1613.5 16

11/16/10

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Page 3

Item ID: D2230-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Lug

Start Date: 5/13/13 Start Qty: 320.00

320

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 320.00

320

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

150

150

QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

200 x Ø m/f 13/05/23

160

160

Powdercoat

Powder Coating

W125620

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

2'15
2'32
2'45

0.00

200 x Ø m/f 13/05/23

170

170

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

200 Ø

DAS:
05
28

13-05-29

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101834

Page 4

Item ID: D2230-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lug

Stop

NS2

Start Date: 5/13/13 Start Qty: 320.00

320

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 320.00

320

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Packaging

57469

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Quality Control

Memo

0.00

13/6/13

13/6/13

13/6/13

Picklist Print

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Page 1

Work Order ID: 101834

Parent Item: D2230-1

Parent Item Name: Lug

Start Date: 5/13/13

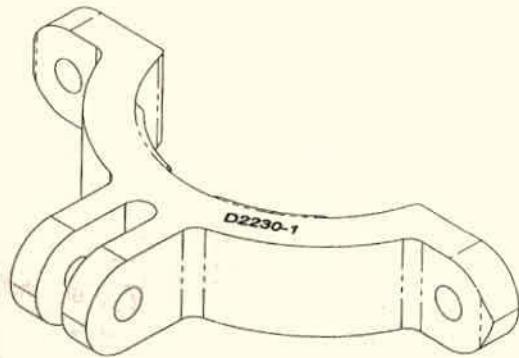
Required Date: 5/31/13

Start Qty: 320.00

Required Qty: 320.00

Comments: IPP D00.11.01 Added inspection level 8, and removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1P LUG		Purchased	No				Each	0.0000		320	143/0/10	(200)	
D2423 Lug Extrusion		Manufactured	No		110	f		588.7400	0.0683	23.006304	02/13/05/14		
				<u>Location</u>			<u>Loc Qty</u>						
				MAT006			383						
				43722			161.5						
				87953			221.5						
				Metec			205.74						
				93551			205.74						23.006



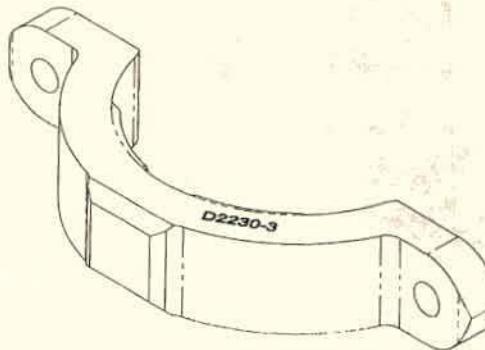
D2230-1 MOUNTING LUG

CD 13/05/14
W10: 101834

G

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005 .
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

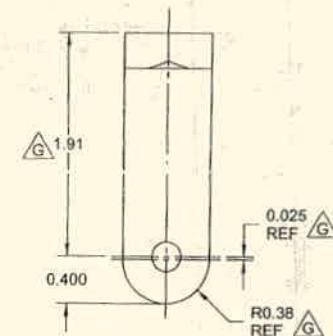
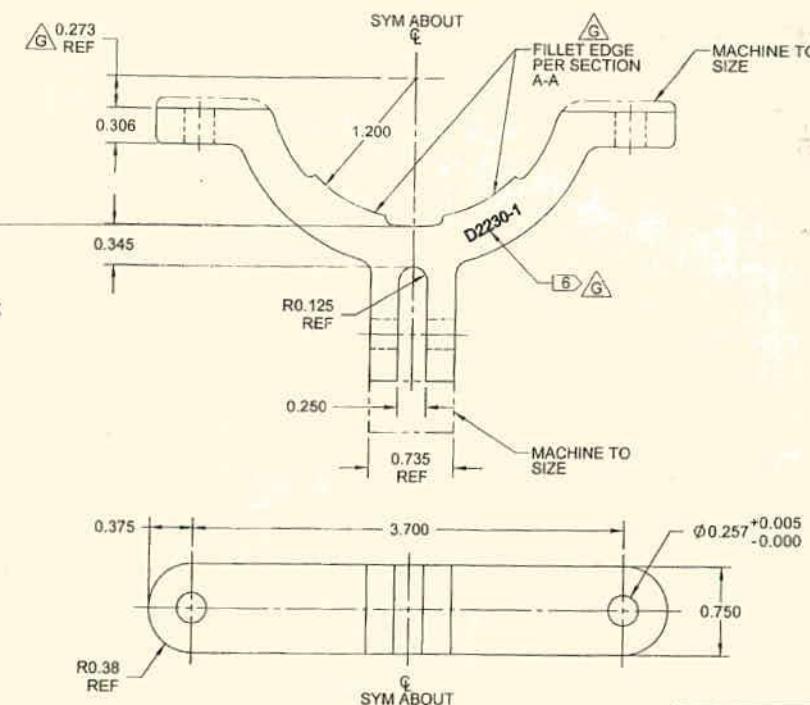
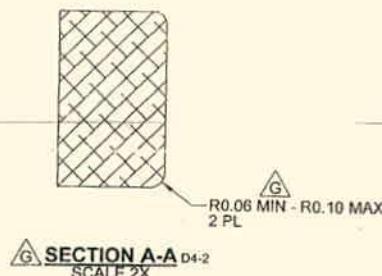
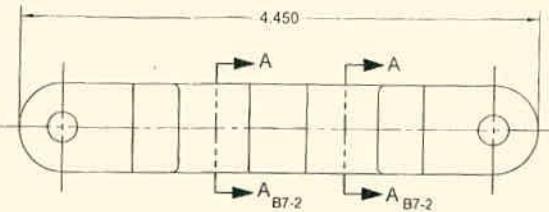


D2230-3 MOUNTING LUG

RELEASED
09/06/2015

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1 200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV. G
MFG. APPR.	<i>John</i>	D2230	SHEET 1 OF 3
APPROVED	<i>John</i>	TITLE	SCALE
DE APPR.	<i>John</i>	MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

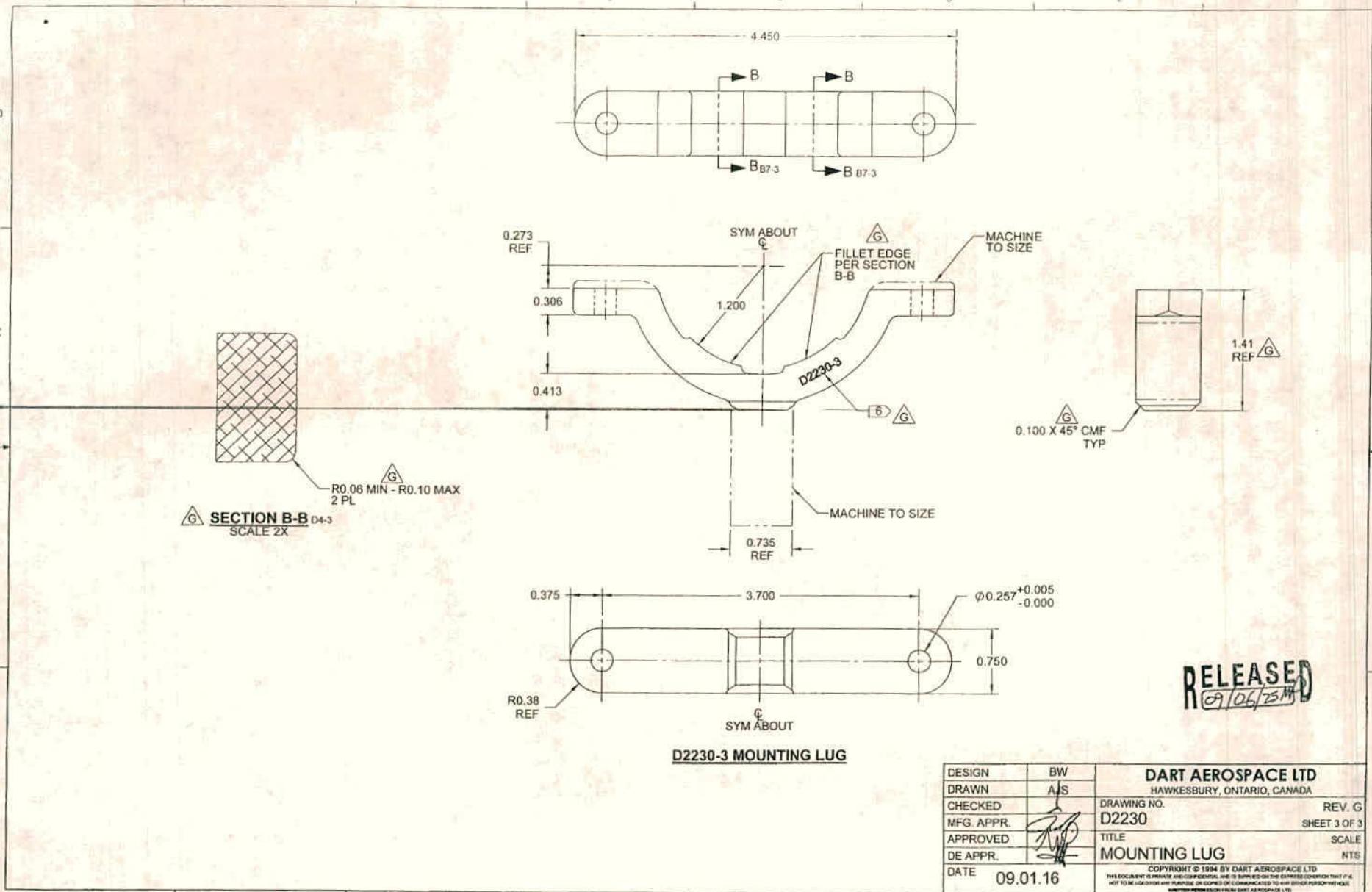
8 7 6 5 4 3 2



RELEASED
09/06/25 AM

DESIGN	BW	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. G
MFG. APPR.		DRAWING NO. D2230
APPROVED		SHEET 2 OF 3
DE APPR.		TITLE MOUNTING LUG
DATE	09.01.16	SCALE NTS

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DESIGN	BW	DART AEROSPACE LTD
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. G
MFG. APPR.		D2230
APPROVED		SHEET 3 OF 3
DE APPR.		TITLE
DATE	09.01.16	SCALE
		MOUNTING LUG
		NTS

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RELEASED
01/06/15

METEC METAL TECHNOLOGY INC.

20 Terry Fox Drive
 Vankleek Hill, Ontario K0B 1R0, Canada
 Tel: (613) 678-3957
 Fax: (613) 678-3956

Delivery Slip No.: 19036
 Date: May 13, 2013
 Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 19868	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: May 15, 2013

	Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3	Mounting Lug as per drawing D2230 REV.G , B101450	Each	300	200	100
D2230-3	Mounting Lug as per drawing D2230 REV.G, B101495	Each	300		300
D2230-1 B101834	Mounting Lug as per drawing D2230-1 REV.G,	Each	320	200	120
D3235-1 B101559	Mounting Lug as per drawing D3235-1 REV.A,	Each	200	100	100
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____	Thank you for your order!				



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

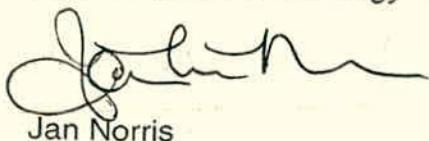
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Lug	PO 19868
200	D2230-1	Lug	PO 19868
100	D3235-1	Lug	PO 19868

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.



A handwritten signature in black ink, appearing to read "John" or "Jan".

Jan Norris

Vankleek Hill, May 15, 2013